

Date: Wednesday, 6/27/2007 3:26:01 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: HOUSING	
Job Number	: 33240				
Estimate Number	: 11870				
P.O. Number	: N/A		Part Number	: D22071	
This Issue	: 6/27/2007	S.O. No. : N/A	Drawing Number	: D2207 REV C PRELIM	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C PRELIM	
Previous Run	: N/A		Material	: N/A	
Written By			Due Date	: 7/4/2007	
Checked & Approved By	: 07.06.28		Qty:	10 Um: Each	
Comment	: Est. A 01.03.08 New Issue				

Additional Product	POSITIVE RECALL	
	EFFECTIVE	07.06.28 AUTH 1
	RELEASED	07.06.28 DATE

Job Number:	
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Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet 
		Comment: Qty.: 0.4375 sf(s)/Unit Total : 4.3754 sf(s) 6061-T6 .063 Sheet 5052-H32 or 6061-T6 -.063" Thick Batch M100385 <i>15 07-06-28</i>
2.0	SHEAR	SHEAR 
		Comment: SHEAR Shear blanks: 4.200" x 14.00" +.000"/-.030" Grain along 14.00"
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA031 Deburr
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>15 07-06-28</i>
5.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK <i>Errol 6/29</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/03/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
01/03/09	6	1 piece was out of tolerance	Initial Chief Eng 01/03/09	Scrap & destroy	SB 01/03/09	Initial QA/TC 01/03/09	QA/TC 01/03/09	QA/TC 01/03/09

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING

Job Number: 33240

Part Number: D22071

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend as per dwg D2207

SD 07/07/09 (9)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

in 07/07/10 (PP)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

SD 07/07/09 (9)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/09

Job Completion



POSITIVE RECALL

EFFECTIVE 07/07/10 AUTH~~07/07/10~~

RELEASED 07/07/10 DATE 07.07.10

07.07.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33240
Description: Housing	Part Number:	D2207-1
Inspection Dwg: D2207	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

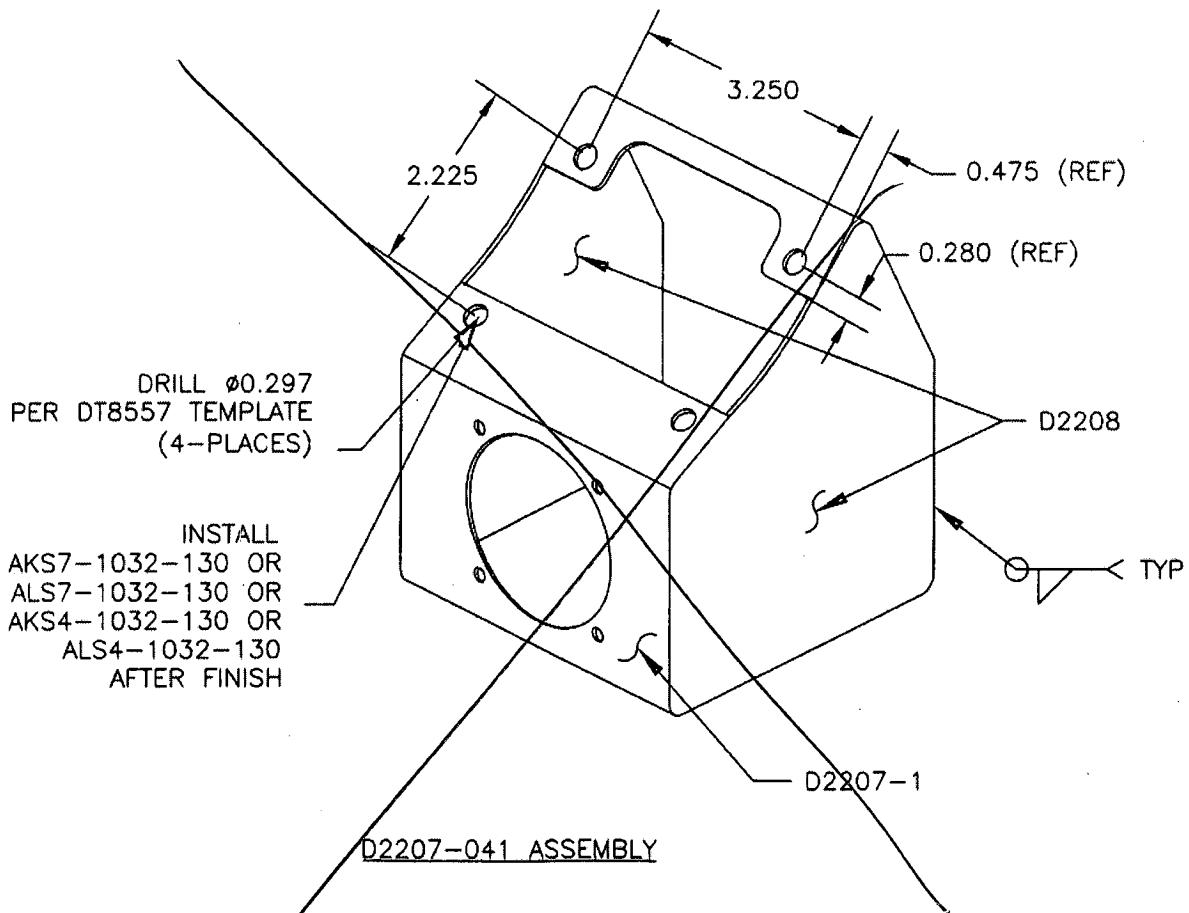
Measured by: <u>ML</u> / <u>IB</u>	Audited by: <u>SA</u>	Prototype Approval:	N/A
Date: <u>07-06-20</u>	Date: <u>07/06/20</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	P/O D206-539-013	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2207	REV. B SHEET 1 OF 2
DATE 01.02.23		TITLE HOUSING	SCALE 1:2
A	94.09.01	NEW ISSUE	
B	01.02.23	REDRAWN	

RELEASED
01.02.27



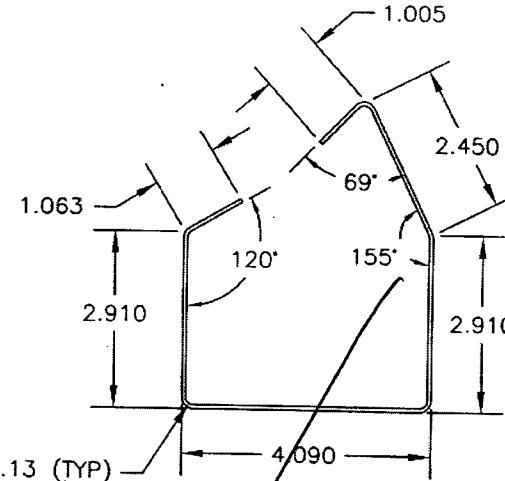
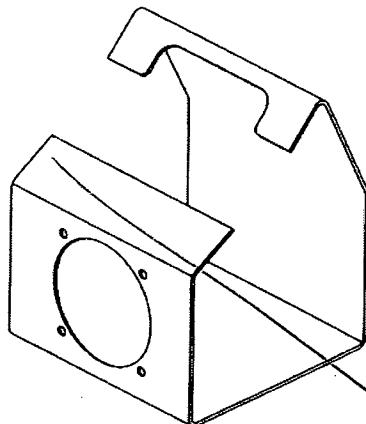
NOTE:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT CLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

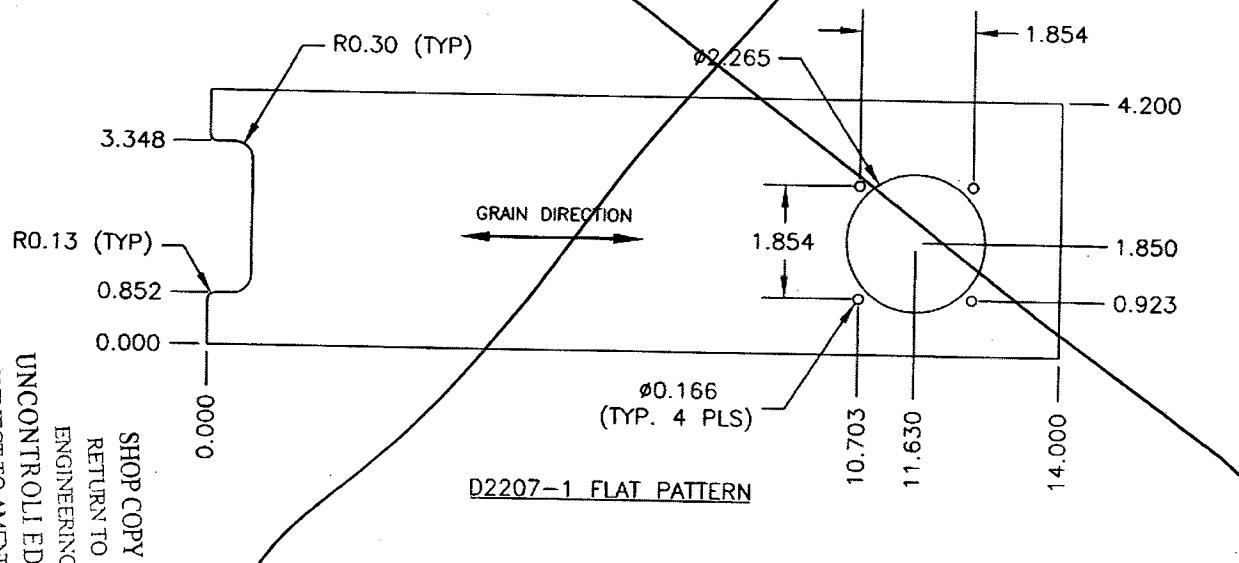
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33240

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2207	REV. B	SHEET 2 OF 2
DATE 01.02.23	TITLE HOUSING	SCALE 1:3		

RELEASED
02.27.94

D2207-1 BENDING DETAIL



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 33240SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY

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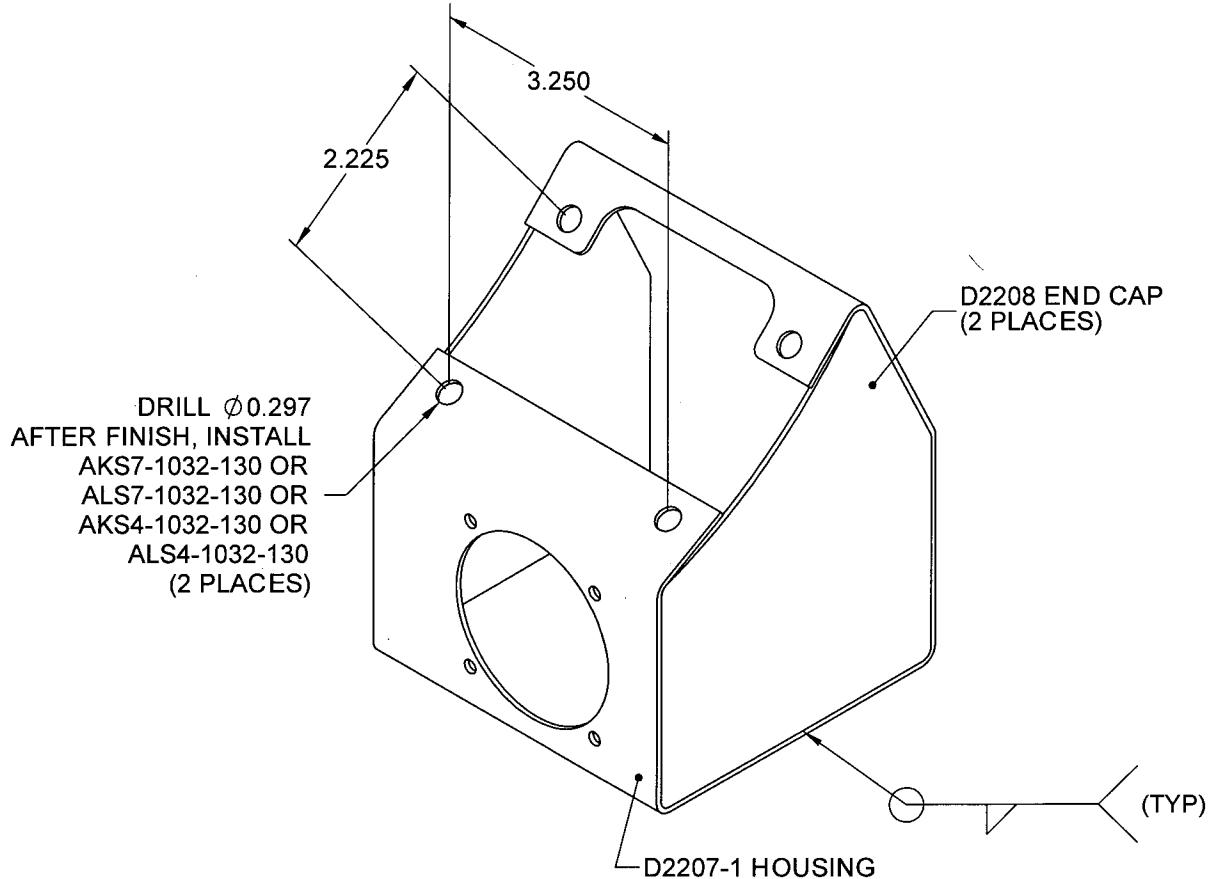
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PRELIMINARY ISSUE

07.06.28

DESIGN <i>PK</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>AS</i>	APPROVED	DRAWING NO. D2207	REV. C	SHEET 1 OF 2
DATE 07.06.28		TITLE HOUSING	SCALE	1:2

REV	DATE	DESCRIPTION
A	94.09.01	NEW ISSUE
B	01.02.23	REDRAWN
C	07.06.28	REDESIGN



D2207-041 FLAT PATTERN

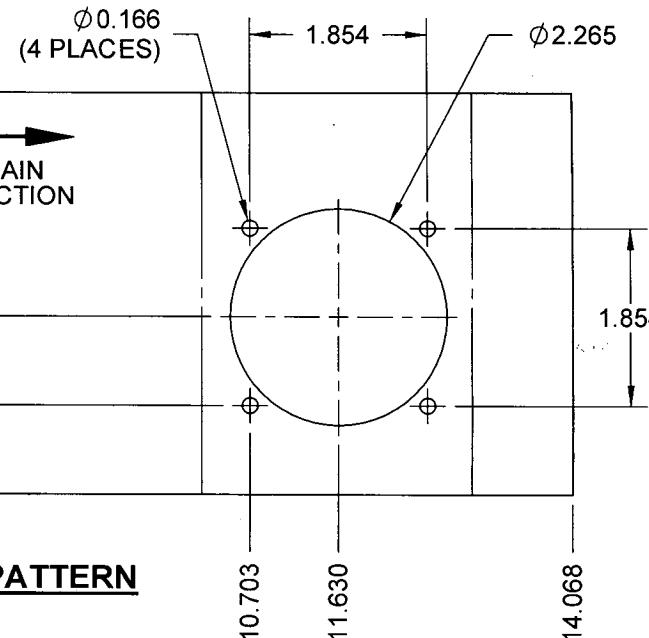
NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

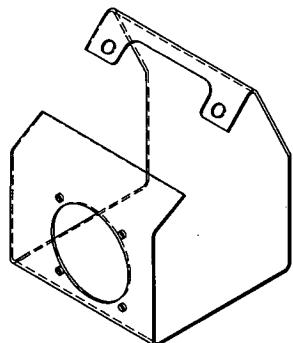
PRELIMINARY ISSUE

07.06.28

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
	DRAWING NO.	REV. C
	D2207	SHEET 2 OF 2
DATE	07.06.28	SCALE
		1:2



D2207-1F FLAT PATTERN

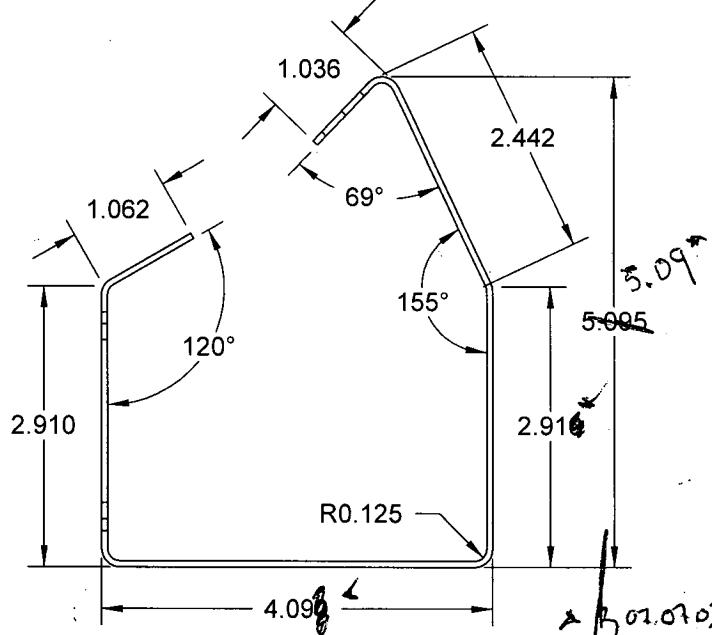


ISOMETRIC VIEW
(SCALE 1 : 4)

D2207-1 HOUSING

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



D2207-1 BENDING DETAIL

